

Work Order ID 130128

Tuesday, February 24, 2015 8:45:34 AM

130128

Page 1

Item ID: D350-636-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Stop ***NS2***

Start Date: 2/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MJS Date: 1502-24 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2750-042	G
D3492	C

DAS
27
998

APR 22 2015

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

record fwd angle:

89.4°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

8888

15-3-9
Mha
[Signature]

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Item ID: D350-636-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Stop ***NS2***Start Date: 2/24/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/24/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.								
	ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE								
	Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for second side only DT8863B for first side (detail K)								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.								
	6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	7- Open up holes of Detail J to 0.297" (total of 2 holes per side)								
	8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004								

15-3-9 *LL*

DGL 15-3-9

15-3-9 *LL*

BE 15-03-09

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N900040100

Setup Start *NS1*

Stop ***NS2***

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

A/R Aluminum Rod batch: m130812

9- Grind welds flush as per Dwg D2750

QC10- Inspect visual per QSI004- ground welds	0.00
---	------

1 20

Memo	0.00
-------------	------

Quality Control

QC5- Inspect part completeness to step on W/O	0.00
---	------

130

Memo	0.00
-------------	------

Quality Control

DAS
9
9-89

① 15-33-10

DAS
9
9-89

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 2/24/2015 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals:  **Process Plan:**

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #**

Plan 'Code

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

Memo

0.00

HandFinish

Hand Finishing

150

QC7-Inspect Chemical Conversion Coat

0.00

150

Memo

0.00

QC

Quality Control

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Item ID: D350-636-012 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.
Start Date: 2/24/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/24/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

160

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Open up holes of Detail L using hole saw and ground handling to 0.625"
(total of 8 holes per side) as per dwg D2750.

2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float holes using uni-bit to .500" (4 per Side)

4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750
(welding instructions on sheet 9)

5- Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7- Bond web D2739 in place as per QSI 015, let cure for 12hrs.

A/R Sikaflex-291 batch: 131524
exp. date: 15-10-21

****ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)****

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 9)

A/R Aluminum Rod batch: M127865

9- At section AP-AP drill out x-bolt spacer to 0.404"

10- Grind welds flush as per Dwg D2750

15-3-10 *[Signature]*

DOL
15-3-10 *[Signature]*

8615-03-16

15-3-17 *[Signature]*

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VERIFY C'BOARD IS GOOD

15-3-17

DAS
38
9-89

15-03-27

DAS
38
9-89

15-03-24

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Item ID: D350-636-012 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.
Start Date: 2/24/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/24/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1	0	15-3-27	DGC
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00							
200									
SprayPaint	Memo	0.00							CR 1503.30
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>130992</u>								
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>131841</u>								
210	QC14- Inspect Spray Paint	0.00				1311	0	15/04/06	
210									
QC	Memo	0.00							Pro
Quality Control	Inspect for foreign object per QSI 024								

DAS
15
9-89

DQA:

Date:

15/05/15



QA Closed:

Date:

15/05/11

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>130128</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D350-636-012</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-4924</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		15-04-09	200	①	found at inspection some particles of dust on bottom of tube with while hanging in paint booth. EC operator	 03/02/02 15/04/09	scuff & re paint B# 131841	DAS 41 9-89 15-4-9	PD 15-04-09	PD 15-04-09
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator	✓									
Offset/Setup										
Process	✓									
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☒ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Item ID: D350-636-012 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.
Start Date: 2/24/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/24/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>M131574</u>								
	EXP DATE: <u>15110</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>M131349</u> RTU 598 M125792 exp 15101								
	5-Coat all exposed fasteners with "LPS Procyon"								
	batch: <u>M122900</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89

APR 16 2015

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N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

NR2

250	Pick Kit	0.00	27
-----	----------	------	-----------

Pick Kit

Packaging Memo

Packaging

0.00

0.00

DAB
27
9-88

APR 21 2015

260 QC4- 100% Inspect kits for completeness

0.00

Memo

QC Memo

Quality Control

0.00

DAS
86
9-89

APR 22 2015

270	0.00
-----	------

Packaging

Packaging Memo

Packaging	Package as per PPP D350-636-012
-----------	---------------------------------

0.00

072

DA8
66
9-89

21
15-04-22

Work Order ID 130128

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Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.
Start Date: 2/24/2015 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 2/24/2015 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

MCS 1504-23

15.4.22

Picklist Print

Page 1

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Work Order ID: 130128

130128

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD
 IPP Rev:K 06-07.13 / As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT-RH		Manufactured	No			110	Each	0.0000	1	1			
D2600-3-BENT-RH						<u>128 986</u>			**①			15-3-9	
Extrusion Bent RH													
D2744		Manufactured	No			110	Each	40.0000	1	1			
D2744									**			15-03-09	
Cap													
				<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>				
				LG001		40							
				<u>128212</u>		40							
D2739		Manufactured	No			160	Each	1.0000	1	1			
D2739									**			15-3-10	
350 I Beam													
				<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>				
				LG		1							
				<u>130074</u>		1							
				129054		1							

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Work Order ID: 130128

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 62.0000 8 8

D2743

Crossbolt Spacer

BE15-03-16
B129465 x B

Location Loc Qty Loc Code

LG001 62
128943 62

D3490-3 Manufactured No 160 Each 43.0000 4 4

D3490-3

Cross Bolt Spacer

BE15-03-16

Location Loc Qty Loc Code

LG001 43
(129055) 43

D3490-1 Manufactured No 160 Each 45.0000 4 4

D3490-1

Cross Bolt Spacer

BE15-03-16

Location Loc Qty Loc Code

LG001 45
(128984) 45

D3631-1 Manufactured No 230 Each 182.0000 8 8

D3631-1

Washer

all 1510412

Location Loc Qty Loc Code

FP001 182
128320 82
128910 100

B129928

x 0

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

32.0000

1

1

D3794-1

**

15/04/15

Gasket Fwd

Location

Loc Qty

Loc Code

FP001

32

125916

6

128238

26

X1

NAS1611-010

Purchased No

230

Each

300.0000

8

8

NAS1611-010

**

15/04/15

O-RING

Location

Loc Qty

Loc Code

FP001

300

m130797

4

m131329

96

m131618

200

M131770

X2

D2741

Manufactured No

250

Each

11.0000

1

1

D2741

**

DAS

27

9-89

Replacement Blade

APR 21 2015

Location

Loc Qty

Loc Code

FG

10

100664

3

113640

2

115522

5

ST538

1

125892

1

B128028

1

DAS
66
9-89

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Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

539.0000

4

4

***NAS1515H3I ***

Washer

**

1510415

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

55

m127831

55

ST266

444

m127831

48

m130726

396

8

8

**

1510415

Location

Loc Qty

Loc Code

FP001

678

m130758

678

8

8

**

1510415

AN3C6A

Purchased

No

230

Each

440.0000

4

4

AN3C6A

Bolt

Location

Loc Qty

Loc Code

CA

39

m128704

39

FG

10

122416

10

ST338a

391

m128769

391

4

4

**

1510415

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Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

152.0000

1

1

NAS1149C0832R

Washer

**

all 12/04/15

Location

Loc Qty

Loc Code

FP001

8

m114915

8

ST271

144

m125807

144

D3536-25

Manufactured

No

230

Each

18.0000

1

1

D3536-25

Gasket Center

**

all 12/04/13

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

12

125909

1

128578

11

D3794-3

Manufactured

No

230

Each

68.0000

1

1

D3794-3

Gasket Aft

**

all 12/04/15

Location

Loc Qty

Loc Code

FP001

68

125917

4

127383

39

128239

24

92658

1

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D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

953.0000

34

34

AN3C5A

Bolt

all 12/04/15

Location

Loc Qty

Loc Code

FG

5

122800

5

ST338a

526

M130770

10

M130851

16

M131320

500

x34

ST350

422

M131420

422

D3537-1

Manufactured

No

230

Each

139.0000

3

3

D3537-1

Wearpad

all 12/04/15

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

B128762

x3

FP001

121

125911

46

126306

1

127087

60

128225

14

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Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

66.0000

1

1

D3535-25

Wearplate Center

**

all 15/04/15

Location

Loc Qty

Loc Code

FG

2

95077

2

FP002

56

125908

15

128090

16

128224

25

FP007

8

127851

8

X1

D3492-3

Manufactured No

230

Each

245.0000

8

8

D3492-3

Plug

**

all 15/04/15

Location

Loc Qty

Loc Code

FP001

245

125905

2

128476

72

128914

171

13131036

X0

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Parent Item: D350-636-012

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Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

5,324.000

38

38

NAS1149C0332R

WASHER

**

ell 13/04/15

Location

Loc Qty

Loc Code

FP001

2155

m130325

2140

m130466

15

GA

2

125654

2

ST271

3167

125654

44

m131340

1123

m131618

2000

x1 131697

x38

D3488-042

Manufactured

No

230

Each

7.0000

1

1

D3488-042

Blade Fitting RH

**

ell 13/04/15

Location

Loc Qty

Loc Code

FP001

7

125899

7

13128804

x1

ALS4-1032-225

AELS8-1032-225

Purchased

No

230

Each

2,586.000

38

38

ALS4-1032-225

Rivnut

**

ell 13/04/15

Location

Loc Qty

Loc Code

FG

120

M127028

120

FP001

41

M131067

41

st549

2425

M131582

2425

x38

Picklist Print

Page 10

Tuesday, February 24, 2015 8:45:38 AM

Work Order ID: 130128

130128

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3492-1

Manufactured No

230

Each

277.0000

8

8

D3492-1

all 15/04/15

Plug

Location

Loc Qty

Loc Code

FP001

277

128509

156

128955

121

X2

D3793-1

Manufactured No

230

Each

28.0000

1

1

D3793-1

all 15/04/15

Wearplate Fwd

Location

Loc Qty

Loc Code

FP002

28

125914

18

128235

10

X1

AN8C35A

Purchased No

230

Each

5.0000

1

1

AN8C35A

all 15/04/15

Bolt

Location

Loc Qty

Loc Code

FG

5

M131856

121275

5

Y1

MS21083C8

Purchased No

230

Each

135.0000

1

1

MS21083C8

all 15/04/15

Nut

Location

Loc Qty

Loc Code

ST299

100

m131618

100

ST300

35

m131049

35

X1

Picklist Print

Tuesday, February 24, 2015 8:45:38 AM

Page 11

Work Order ID: 130128

130128

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No 230 Each 199.0000 8 8

D2745

Bushing

HL 15/04/17

Location	Loc Qty	Loc Code
FP001	18	
128920	18	B129584
ST010	100	
128480	100	
ST012a	81	
128089	81	

✓8

AN6C44A Purchased No 230 Each 146.0000 4 4

AN6C44A

Bolt

HL 16/04/17

Location	Loc Qty	Loc Code
FG	2	
103964	2	M131651
FP001	5	
m130863	4	M131856
m131367	1	
ST286A	13	
m130863	13	
ST332	11	
m130863	11	
ST333	115	
m131151	50	
m131546	65	

✓1

✓3

Picklist Print

Tuesday, February 24, 2015 8:45:38 AM

Work Order ID: 130128

130128

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3532-1 Manufactured No

250 Each 42.0000 2 2

D3532-1

Spacer

DAS
86
9-89

**

DAS

27

9-89

Location

Loc Qty

Loc Code

ST048

42

125907

2

128091

40

B128964

2

MS21083C8 Purchased No

250 Each 135.0000 2 2

MS21083C8

Nut

DAS
86
9-89

**

DAS

27

9-89

Location

Loc Qty

Loc Code

ST299

100

m131618

100

ST300

35

m131049

35

2

NAS1149D0863J Purchased No

250 Each 718.0000 2 2

NAS1149D0863J

Washer

**

DAS

27

9-89

Location

Loc Qty

Loc Code

FP001

57

125484

57

ST260a

661

125268

561

125635

100

2

DAS
86
9-89

APR 21 2015

Picklist Print

Page 13

Tuesday, February 24, 2015 8:45:38 AM

Work Order ID: 130128

130128

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3493-1 Manufactured No 250 Each 146.0000 2 2

D3493-1

Washer

DAS

27

9-89

DAS
85
9-89

Location

Loc Qty

Loc Code

FG 10

97201 10

ST046 136

125906 35

128755 101

2

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

AN8C21A Purchased No 250 Each 31.0000 2 2

AN8C21A

Bolt

DAS

27

9-89

APR 2 1989

DAS
85
9-89

Location

Loc Qty

Loc Code

FG 2

123966 2

ST332 29

m131100 3

m131547 26

m131856

m131857

m131947

2

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN8C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

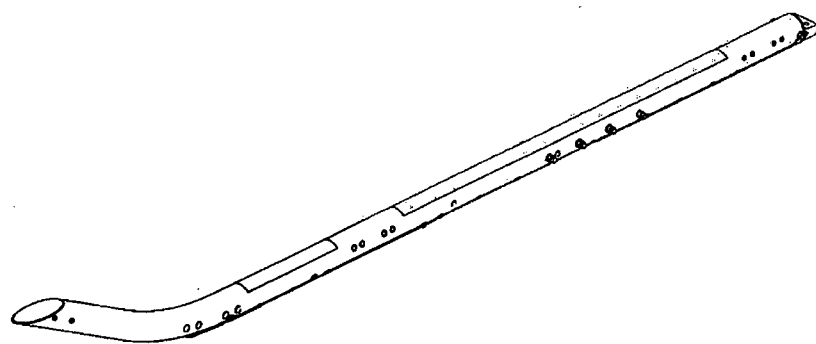
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

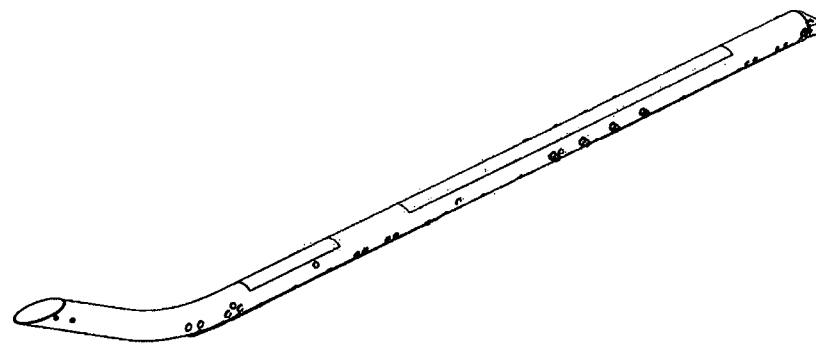
G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PART13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	JB	KENT, WA	
CHECKED	JB	DRAWING NO.	REV. G
MFG. APPR.	JB	D2750	SHEET 1 OF 11
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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2013-08-13
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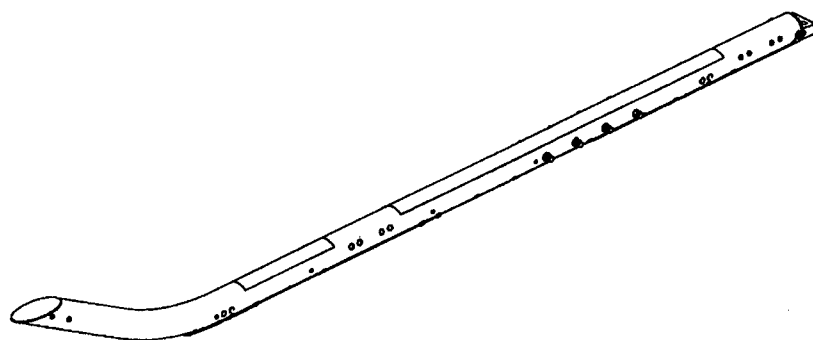
D2750-041 350 SKIDTUBE ASSEMBLY, LH



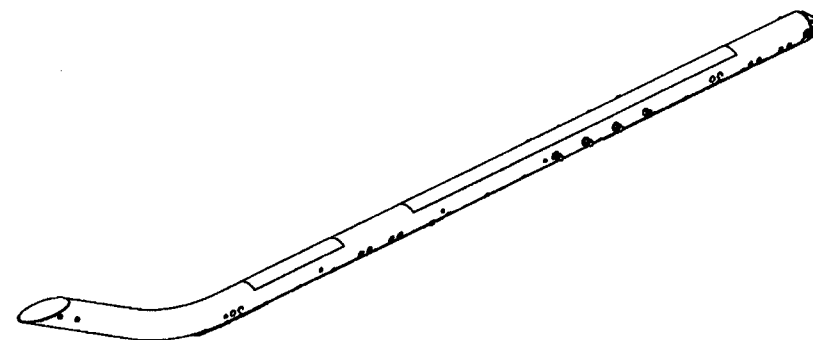
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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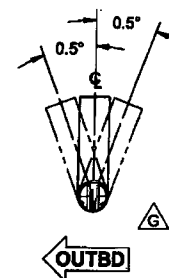
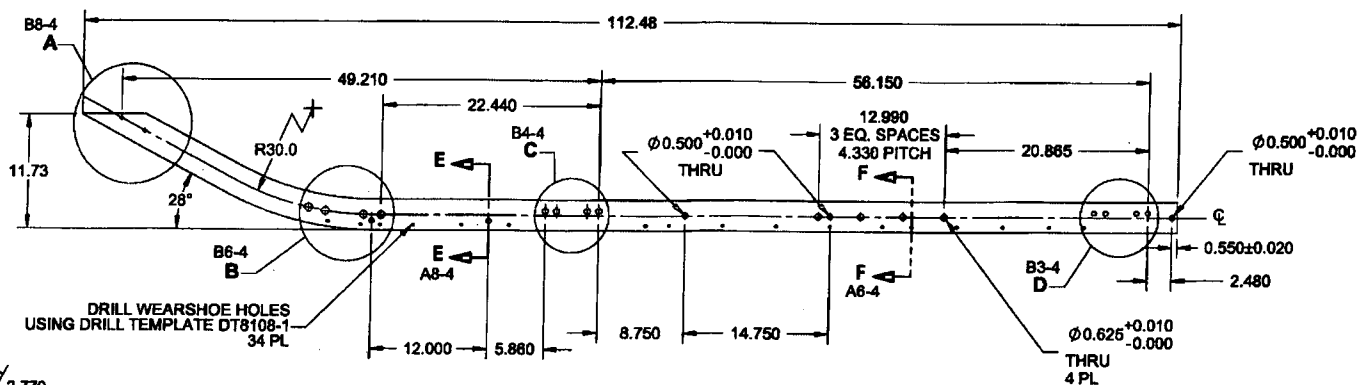
D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

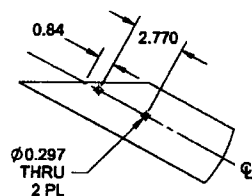
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MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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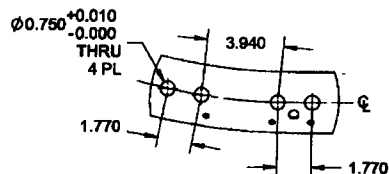


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

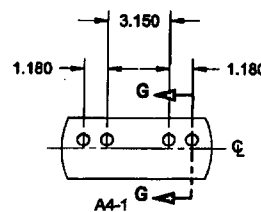
D2750-1 LH SKIDTUBE



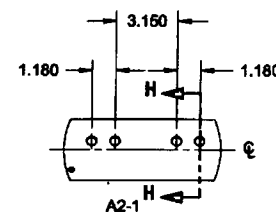
DETAIL A
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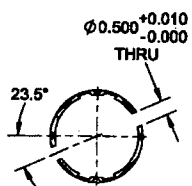
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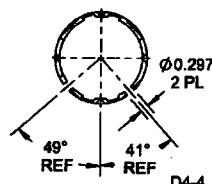
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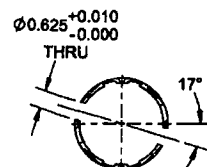
DETAIL D
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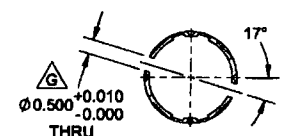
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

DESIGN	MM
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	13.07.11

DART AEROSPACE USA, INC.
KENT, WA

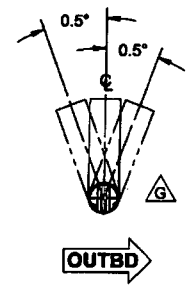
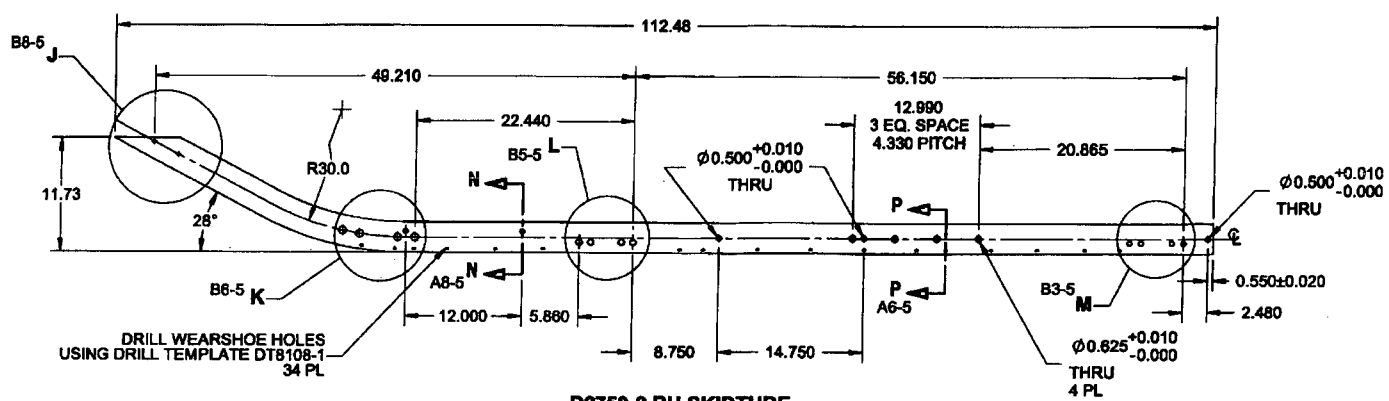
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REV. G

TITLE 350 SKIDTUBE ASSEMBLY
SCALE NTS

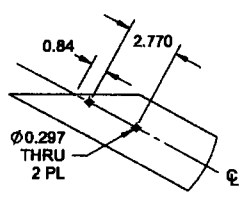
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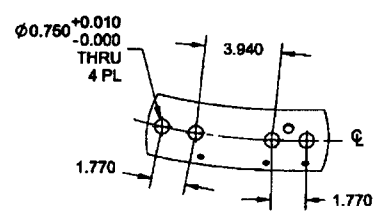
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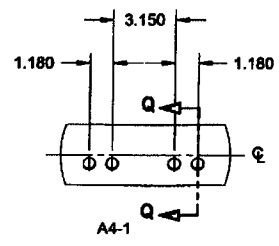
D2750-2 RH SKIDTUBE



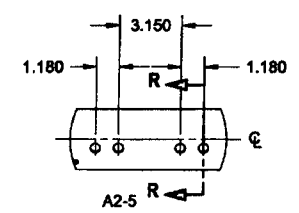
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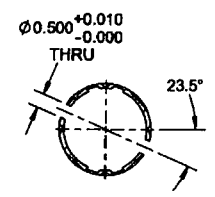
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SCALE 2X



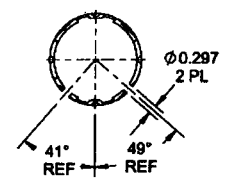
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SCALE 2X



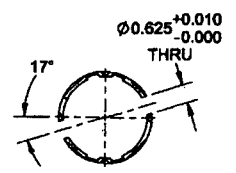
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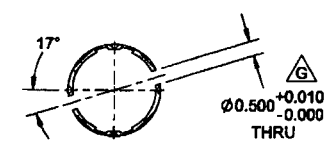
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SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



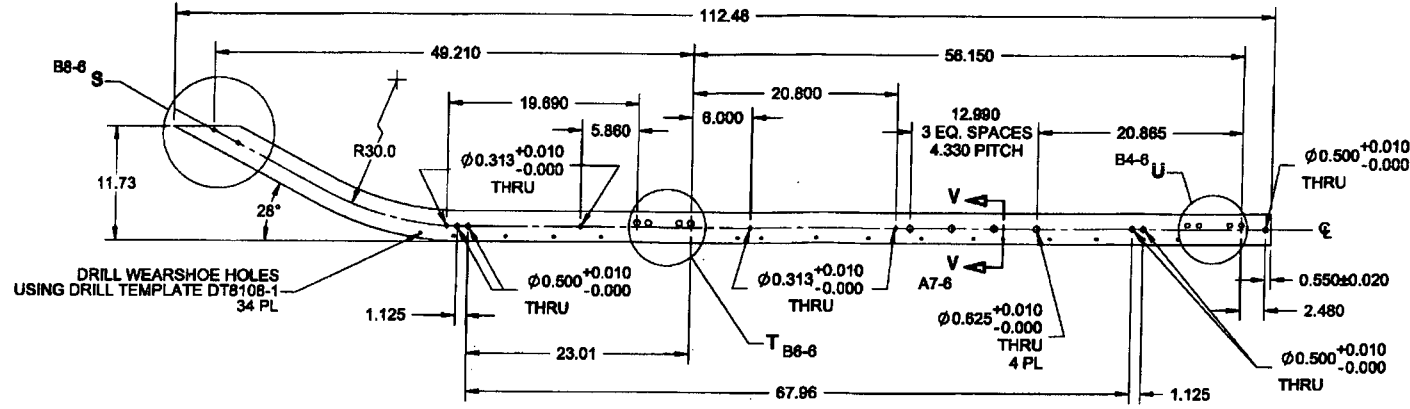
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SCALE 3X, 4 PL

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2013-08-13

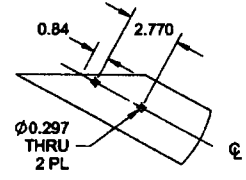
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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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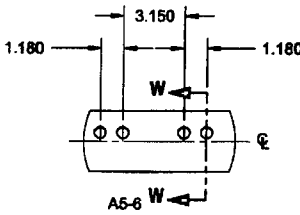
8 7 6 5 4 3 2 1



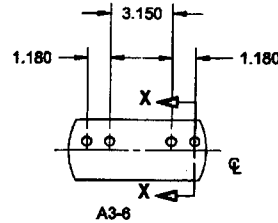
D2750-3 LH SKIDTUBE



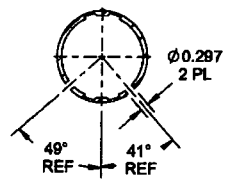
DETAIL S
D8-6
SCALE 2X



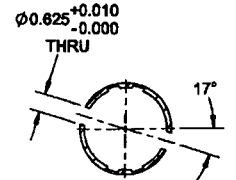
DETAIL T
C5-6
SCALE 2X



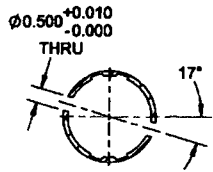
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B8-6
SCALE 3X, 4 PL

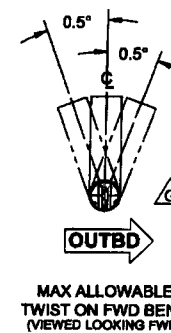
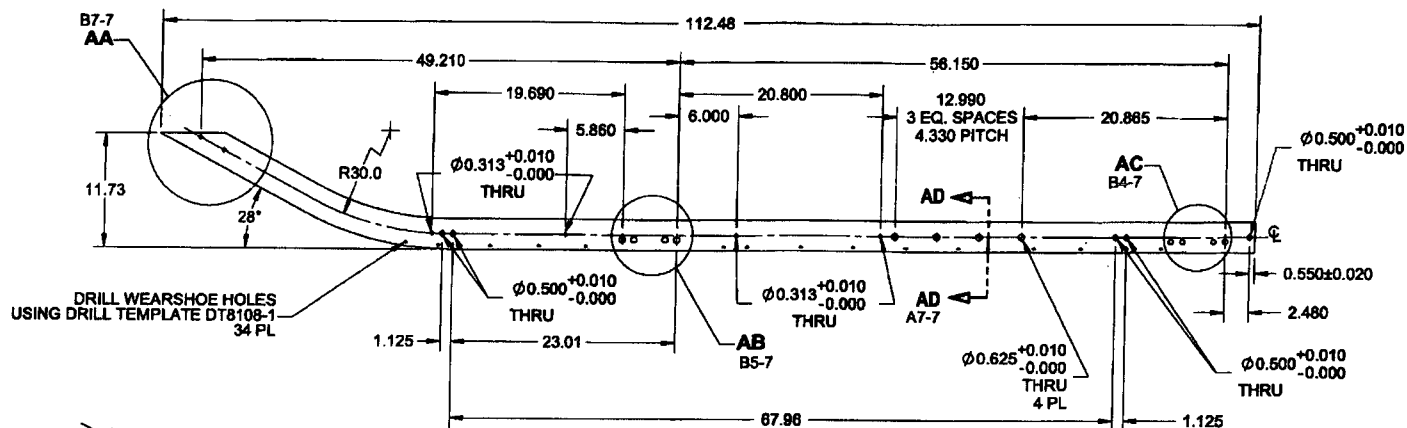


SECTION X-X
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SCALE 3X, 4 PL

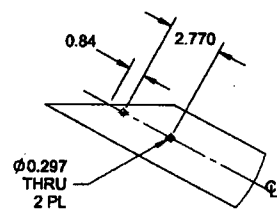
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MFG. APPR.		D2750	SHEET 8 OF 11
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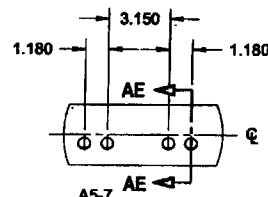
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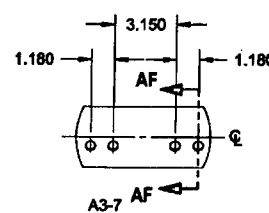
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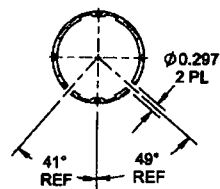
DETAIL AA
D7-7
SCALE 2X



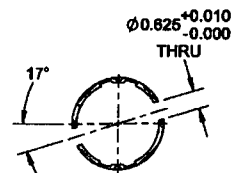
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C4-7
SCALE 2X



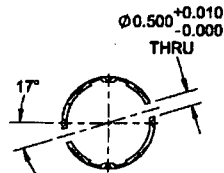
DETAIL AC
D3-7
SCALE 2X



SECTION AD-AD
D3-7
SCALE 3X, 17 PL



SECTION AE-AE
B6-7
SCALE 3X, 4 PL

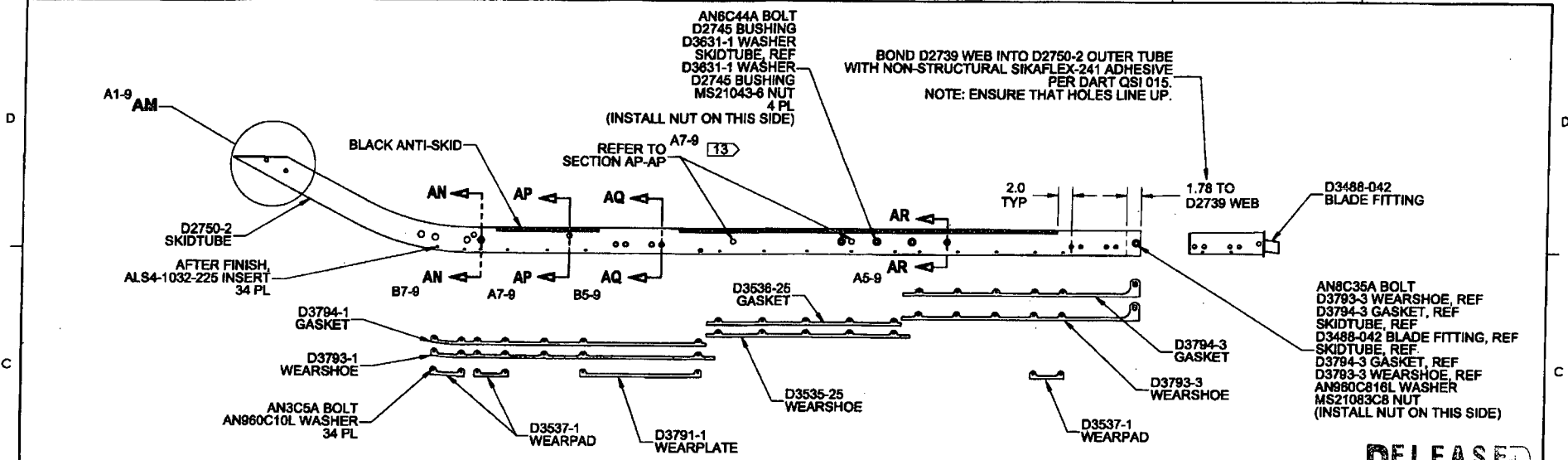


SECTION AF-AF
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SCALE 3X, 4 PL

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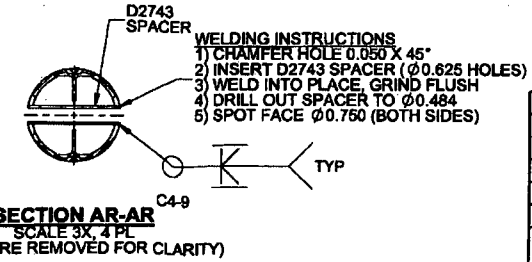
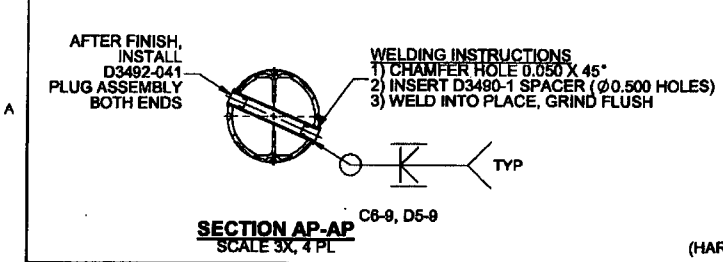
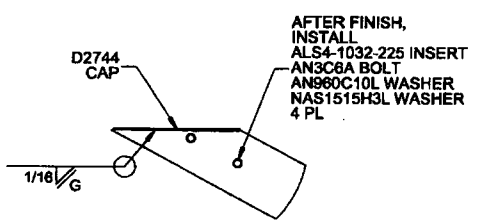
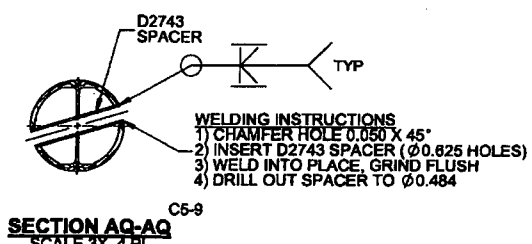
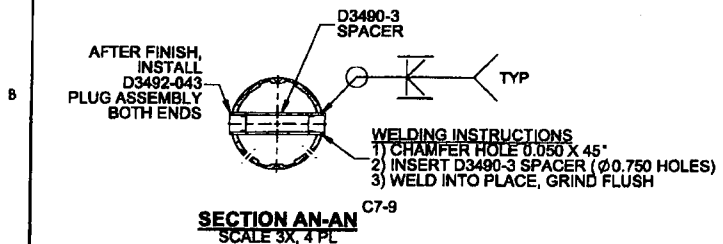
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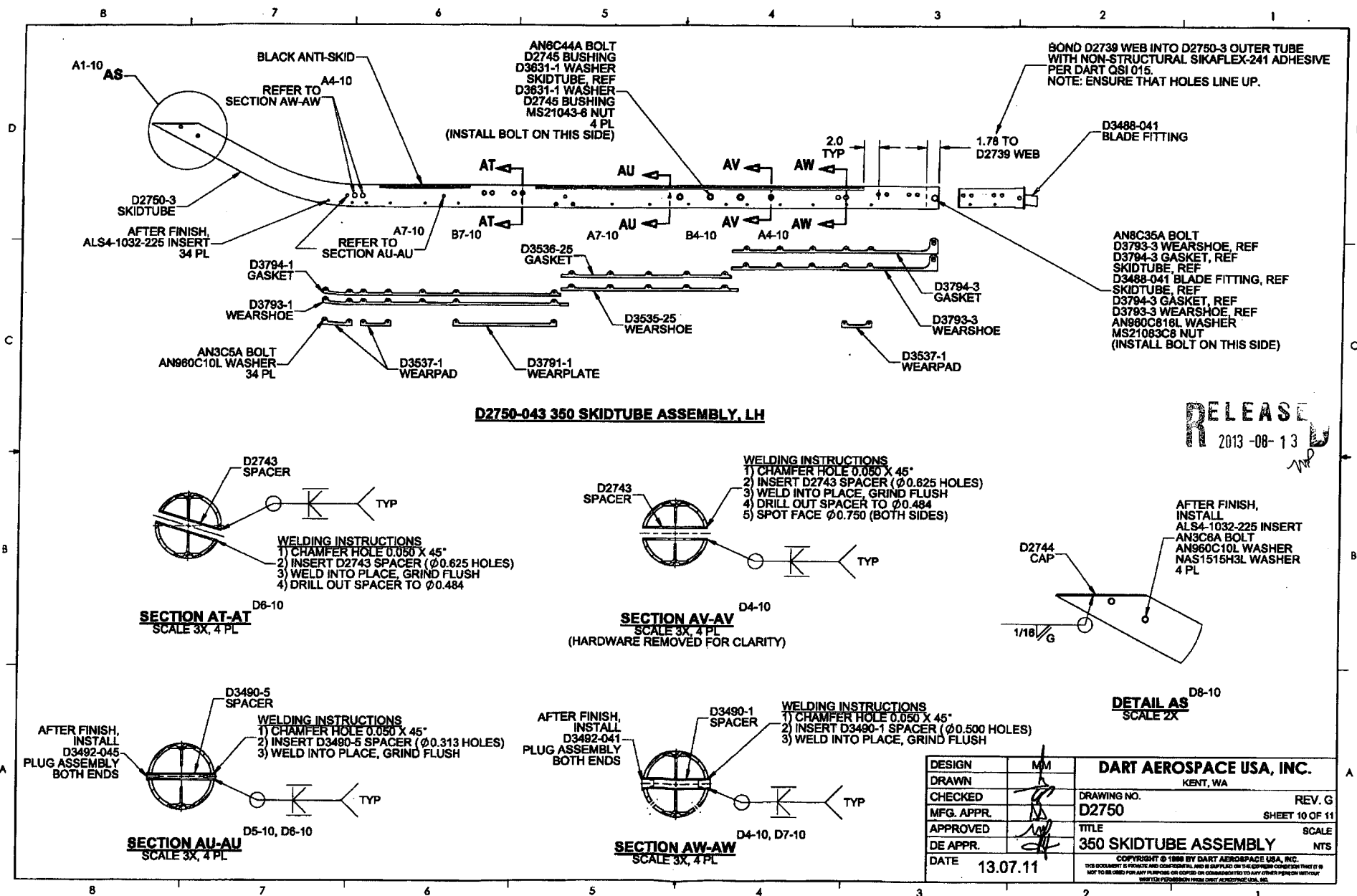


D2750-042 350 SKIDTUBE ASSEMBLY, RH

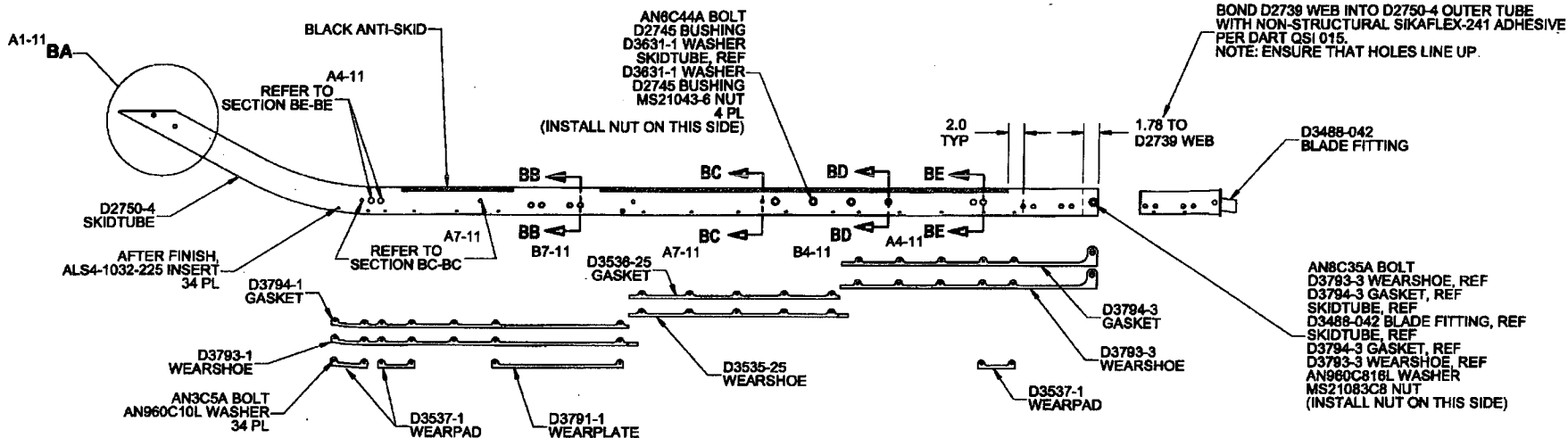
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2013-08-13



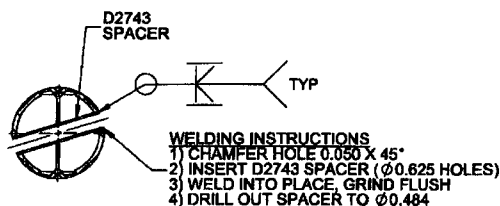
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8 7 6 5 4 3 2 1



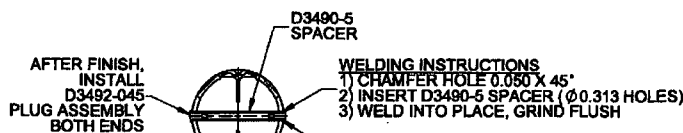
D2750-044 350 SKIDTUBE ASSEMBLY, RH



SECTION BB-BB
SCALE 3X, 4 PL



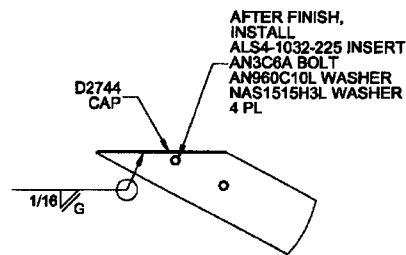
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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8 7 6 5 4 3 2 1